

Work Order ID 52931

October 19, 2009 11:01:33 AM

Page 1

Item ID: D3968-1

Accept

Setup Start

Revision ID: A

Stop

Item Name: Backiing Plate,Door Hinge

Start Date: 10/19/09 Start Qty: 8.00

Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3968	A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3968

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

= 7 m-l oaluloz

12X

12

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-10-09

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Customer:




Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	25 or 10/2			(12)	1		
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI0054.1 Memo	0.00 0.00	MD 09/11/03			12			
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	11 09/11/03			(X12)	1		

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Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>139</u>	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
160	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

09/14/03 (12)

09/11/04 HJ
MF-09-11-04

Picklist Print

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Page 1

Work Order ID: 52931

Parent Item: D3968-1A-PRELIM

Parent Item Name: Backiing Plate, Door Hinge

Comments:

Start Date: 10/19/09

Required Date: 11/02/09

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	105.0952	0.1314			



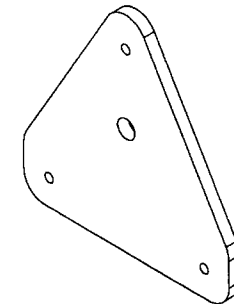
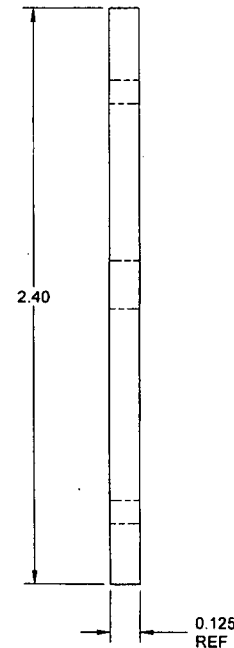
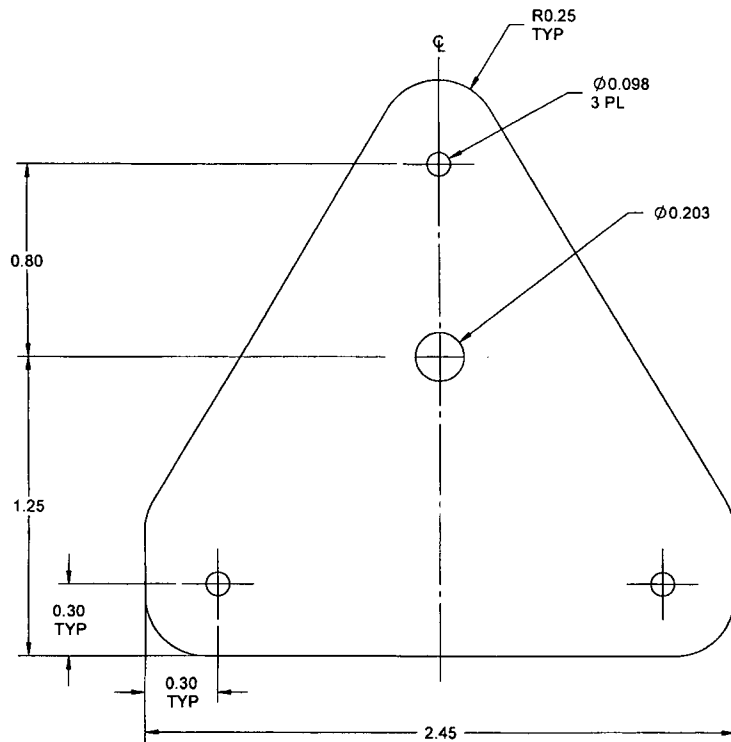
6061-T6 .125 Sheet



KB 9-10-29

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	105.0952	
110062	1.85	
111642	19.592	
112476	32	
112567	51.6532	

112567



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52931

AD 09-10-21

D3968-1 BACKING PLATE, GAS SPRING

RELEASED
2009-10-08
MD

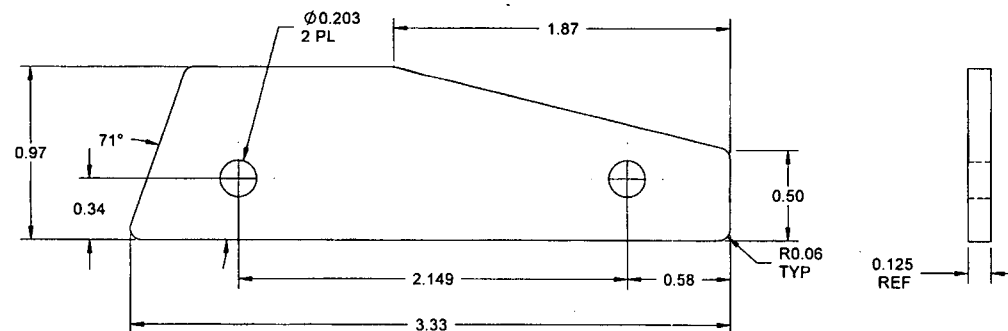
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4027 OR AMS 4025
REF DART SPEC M6061T6S, 125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3968-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs

A NEW ISSUE		BY DATE	
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AS</i>		
DRAWN	<i>AS</i>		
CHECKED	<i>PH</i>		
MFG. APPR.	<i>21</i>		
APPROVED	<i>MD</i>		
DE APPR.	<i>MD</i>		
DATE	09.09.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D3968**
REV. A
SHEET 1 OF 2
TITLE **BACKING PLATE**
SCALE **NTS**

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D3968-3 BACKING PLATE, AIRFRAME HINGE

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SUBJECT TO CHANGE
WITHOUT NOTICE
WORK ORDER
NO. 52931

RELEASED
2009-10-08
AMP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4027 OR AMS 4025
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3968-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3968	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BACKING PLATE	NTS
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